

Work Order ID 104422

July-10-13 11:44:29 AM

104422

Page 1

Item ID: D4035-047

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Lid Rib Assembly, Aft (Light)

Start Date: 7/10/13 Start Qty: 8.00

8

Cust Item ID:

Required Date: 7/24/13 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 13-07-10 Tooling:

Date:

Run Start *NR1*

QC: _____

Date: _____ SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D4035	A
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100 Weld per dwg A/R Aluminum rod Batch: B123928 0.00

100

Large Fab

Memo

0.00

Large Fab

- 1- Cut D4035-7 as per dwg D4035
- 2- Drill hole using DT9620 and chamfer holes as per dwg D4035
- 3- remove identification marks and deburr
- 4- Weld bushing in rib and grind weld flush as per dwg D4035

8x CC 13-7-11

110

QC10- Inspect visual per QSI004- ground welds 0.00

110

QC

Memo

0.00

Quality Control

D4035
2-83

CPC 13-7-14

8x

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Item ID: D4035-047

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Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Lid Rib Assembly, Aft (Light)

Start Date: 7/10/13 Start Qty: 8.00 *8*

Cust Item ID:

Required Date: 7/24/13 Req'd Qty: 8.00 *8*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		PC13-7-19		8			
130 *130* Packaging Packaging	Identify as per dwg & Stock Location: WA5 Memo	0.00 0.00		PC13-7-19		8			
140 *140* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

MLB 13-07-22
PL 13-07-19

Picklist Print

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Work Order ID: 104422

104422

Parent Item: D4035-047

D4035-047

Parent Item Name: Lid Rib Assembly, Aft (Light)

Start Date: 7/10/13

Required Date: 7/24/13

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP RevA: new issue DD 10.01.25 verified by:EC
per dwg revA 10.03.15 verified by:EC
PER DWG REV.pb2 DD VERF:JFS
IPP Rev:B as
IPP Rev:C 13.06.24 AS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D4035-11		Manufactured	No			100	Each	28.0000	2	16			
D4035-11 Bushing													
** CC 13-7-11													

Location	Loc Qty	Loc Code
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WA004	28	
59749	8	
88890	20	

M6061T6TS0.750W.06 2		Purchased	No			100	f	257.7548	1.875	15.78947			
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M6061T6TS0 750W 062
6061-T6 SQ Tube .75 x .75 x .062W

** CC 13-7-11

Location	Loc Qty	Loc Code
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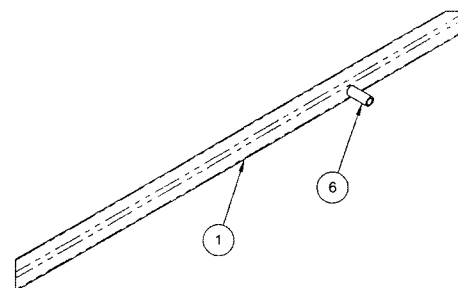
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122200	11.7548	
124595	246	

15.78947

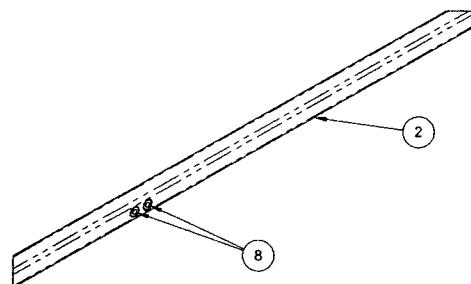
ITEM	QTY -041	QTY -043	QTY -045	QTY -047	P/N	DESCRIPTION
	X				D4035-041	LID RIB ASSY, FWD
		X			D4035-043	LID RIB ASSY, AFT
			X		D4035-045	LID RIB ASSY, FWD (LIGHT)
				X	D4035-047	LID RIB ASSY, AFT (LIGHT)
1	1				D4035-1	RIB
2		1			D4035-3	RIB
3			1		D4035-5	RIB
4				1	D4035-7	RIB
5				2	D4035-11	BUSHING
6	1				D2327-3	SPACER BUSHING
7			1		D2953-175	SPACER
8		2			D4021-9	BUSHING

UNCONTROLLED COPY
SUBJECT TO A RECALL
NO. 104422 M.C.S

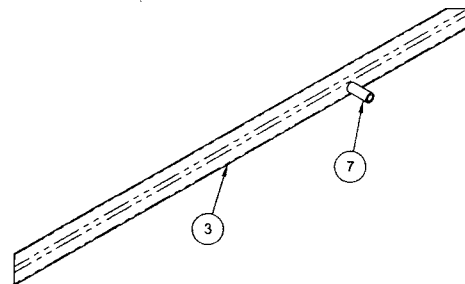
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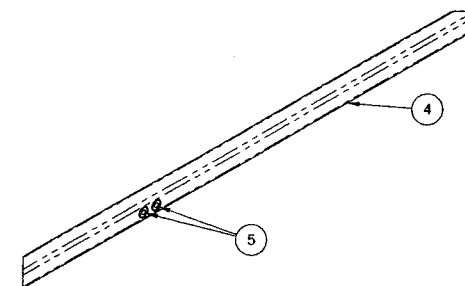
D4035-041 BASKET LID RIB ASSY, FWD



D4035-043 BASKET LID RIB ASSY, AFT



D4035-045 BASKET LID RIB ASSY, FWD (LIGHT)

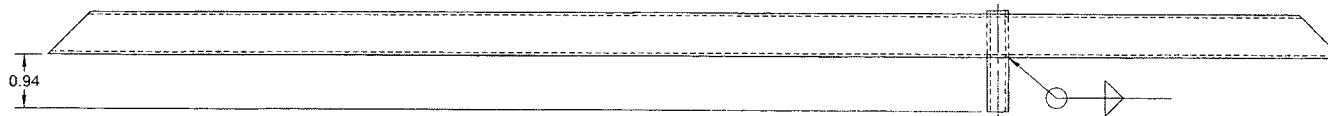


D4035-047 BASKET LID RIB ASSY, AFT (LIGHT)

RELEASED
2010-03-12
AW

REV.	NEW ISSUE	DESCRIPTION	JPH	10.03.04
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	BY	DATE
DRAWN	JPH			
CHECKED		DRAWING NO.	REV. A	
MFG. APPR.		D4035		SHEET 1 OF 5
APPROVED		TITLE	SCALE	
DE APPR.		BASKET LID RIB ASSY	NTS	
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104422



D4035-1
RIB

D2327-3
SPACER BUSHING

D4035-041 BASKET LID RIB ASSY, FWD



D4035-3
RIB

D4021-9
BUSHING
2 PL

G
G
TYP

D4035-043 BASKET LID RIB ASSY, AFT

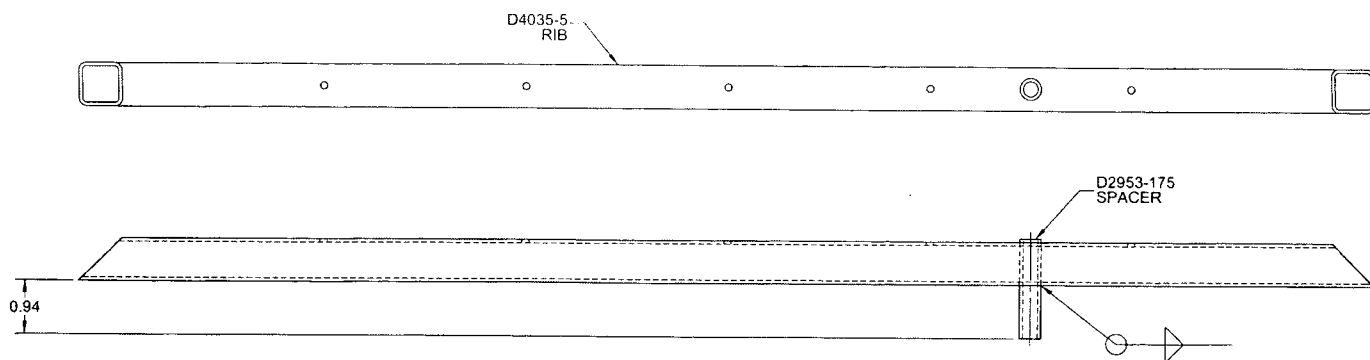
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2010-02-12
WDO

NOTES:

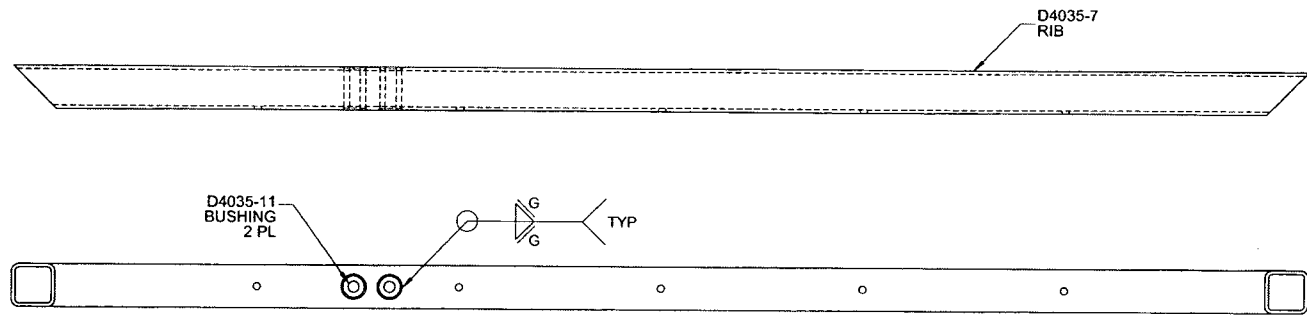
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.83 lbs
- 8) WELDING: PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JFH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4035	SHEET 2 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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D4035-045 BASKET LID RIB ASSY, FWD (LIGHT)



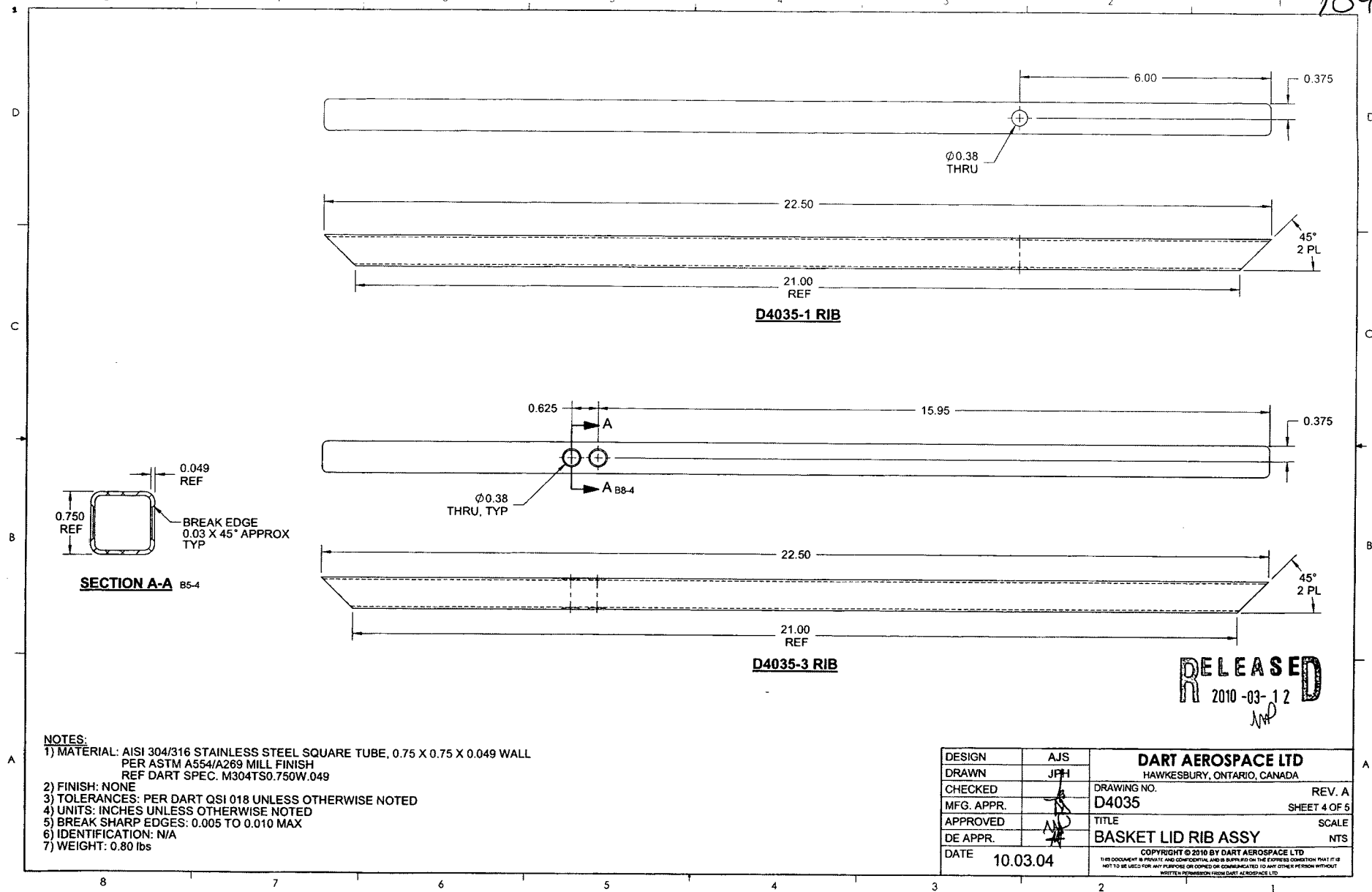
D4035-047 BASKET LID RIB ASSY, AFT (LIGHT)

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2010-03-12

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.34 lbs
 - 8) WELDING: PER DART QSI 004

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APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BASKET LID RIB ASSY	NTS
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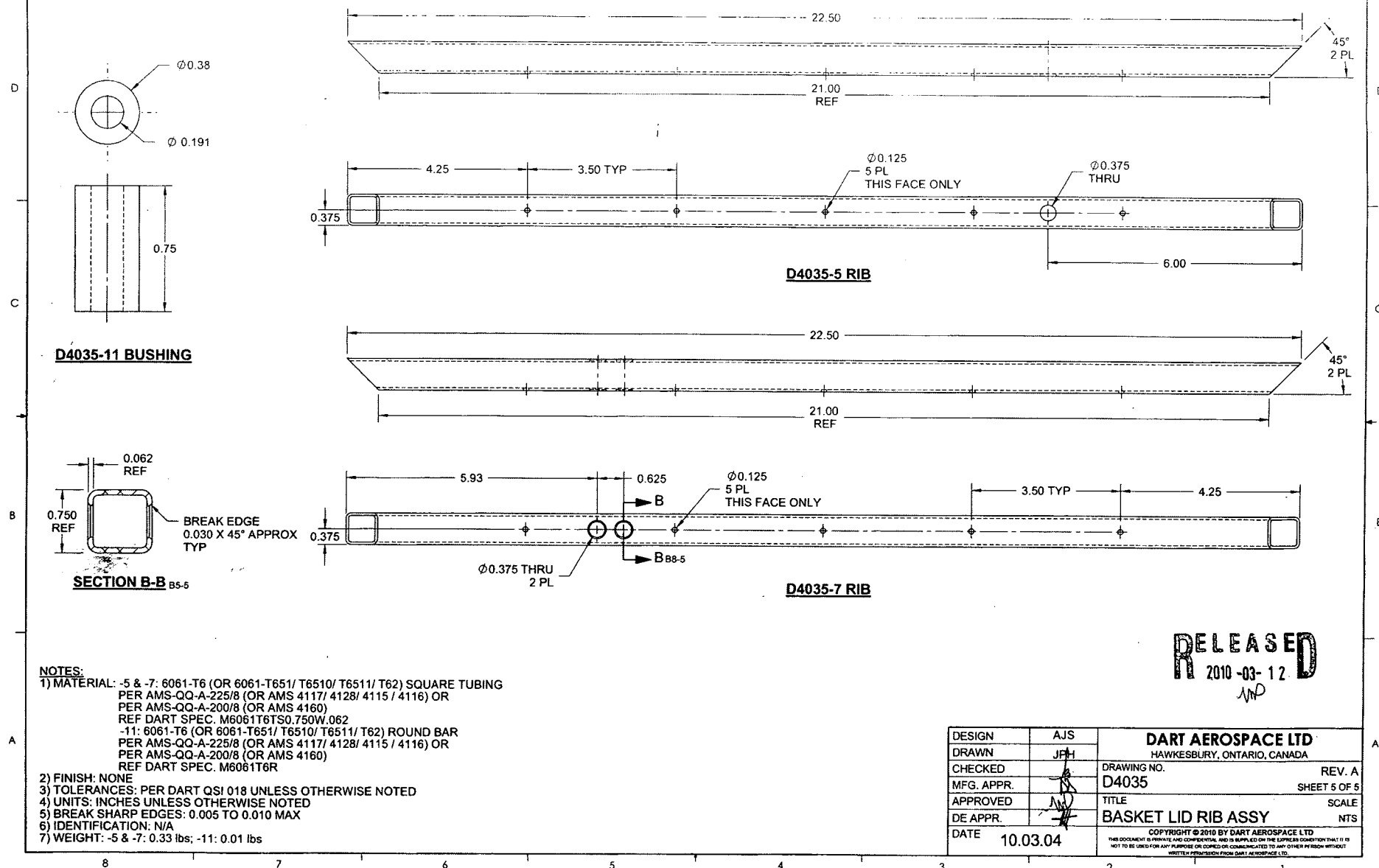


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2010-03-12

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
PER ASTM A554/A269 MILL FINISH
REF DART SPEC. M304TS0.750W.049
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.80 lbs

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